

~~Ship~~ ship files wk 24-25/02

Work Order ID 66625

Wednesday, February 23, 2011 9:20:04 AM

Page 1

Item ID: D3199-3

Revision ID:

Item Name: Bracket, Fwd LH

Start Date: 2/23/2011 Start Qty: 1.00

Required Date: 2/23/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3199

PD1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3199

Dwg Rev: PD1

Prog Rev: PD1

Deburr if required

1311-2-23

2

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1311-2-23

**Work Order ID 66625**

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Item ID: D3199-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket, Fwd LH

Start Date: 2/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00 -inspected to PDI



QC

Memo

0.00

Quality Control

Dry only  
8/10/23

(42)

130

Bend as per dwg  
Small Fab

0.00



Brake NC

Memo

0.00

Brake NC

SS 11/02/25

140

QC5- Inspect part completeness to step on W/O

0.00 -inspected to PDI



QC

Memo

0.00

Quality Control

Dry only  
8/10/25

(4)

## WORK ORDER CHANGES

| W/O: |      |                  |    |      |     |                                     |                          |
|------|------|------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                  |    |      |     |                                     |                          |
|      |      |                  |    |      |     |                                     |                          |

Part No: D399-3 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

| NCR:                         |      |   |                             |                                 |                |                           |                       |                          |
|------------------------------|------|---|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE                         | STEP | Description of NC<br>Section A                  | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|                              |      |   | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
| 11-02-25<br><del>02-25</del> | 130  | swal extra prot<br>only made for head<br>sample | h<br>11-02-25               |                                 | SB<br>11/02/25 |                           | h<br>11-02-25         |                          |
|                              |      |   |                             |                                 |                |                           |                       |                          |
|                              |      |   |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 66625**

Wednesday, February 23, 2011 9:20:04 AM

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Item ID: D3199-3

Accept

Revision ID:

Item Name: Bracket, Fwd LH

Start Date: 2/23/2011 Start Qty: 1.00

Required Date: 2/23/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

145

0.00



Small Fab

Memo

0.00

Small Fab

ROLL AS PER DWG

147

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

150

0.00



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

Powder Coating

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

**Work Order ID 66625**

Wednesday, February 23, 2011 9:20:04 AM

Page 4

Item ID: D3199-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket, Fwd LH

Start Date: 2/23/2011 Start Qty: 1.00

Required Date: 2/23/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg &amp; Stock Location: 0.00



Packaging

Memo

Packaging

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

Quality Control

POSITIVE RECALL

EFFECTIVE 11/02/23 AUTH TA

RELEASED DATE

CU 11/02/25 ENG406

# Picklist Print

Wednesday, February 23, 2011 9:20:01 AM

Page 1

Work Order ID: 66625



Parent Item: D3199-3



Parent Item Name: Bracket, Fwd LH


Start Date: 2/23/2011

Required Date: 2/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: RevC-prelim DD verified by:EC

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S20GA<br><br>304/316 .040 Sheet |                        | Purchased     | No          |                     |                  | 100             | sf                 | 111.0938       | 0.3371      | 0.354842     |               |                |        |



B11-2-23

Location

Loc Qty

Loc Code

MAT

111.0938

115953

21.6

116437

52.2538

116623

37.24

116623

2



|                              |      |              |             |
|------------------------------|------|--------------|-------------|
| DART AEROSPACE LTD           |      | Work Order:  | 66625       |
| Description: Pass LH Bracket |      | Part Number: | D3199-1 Bo  |
| Inspection Dwg:              | Rev: |              | Page 1 of 1 |

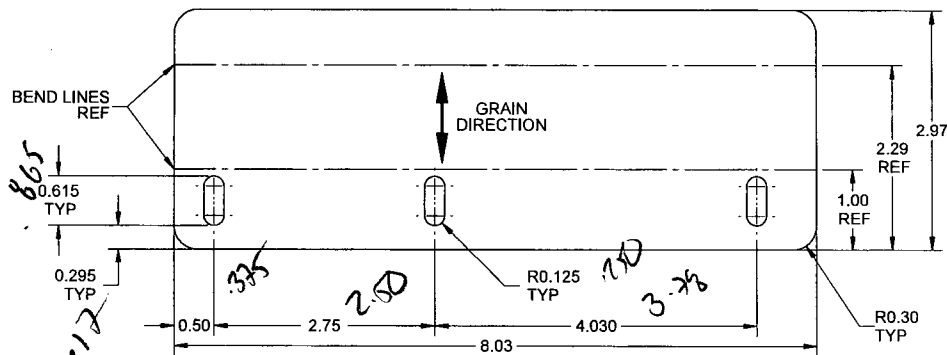
☒ **First Article**      ☐ **Prototype**

[illegible]

|              |          |             |          |                     |     |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | JS       | Audited by: | S        | Prototype Approval: | N/A |
| Date:        | 11/02/25 | Date:       | 11/02/25 | Date:               | N/A |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |





# **D3199-3F FLAT PATTERN**

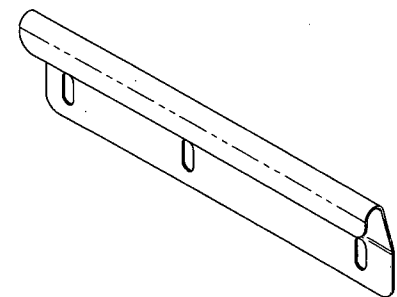
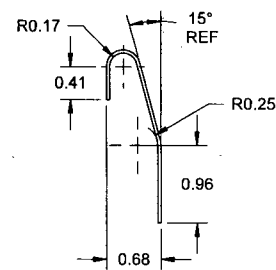
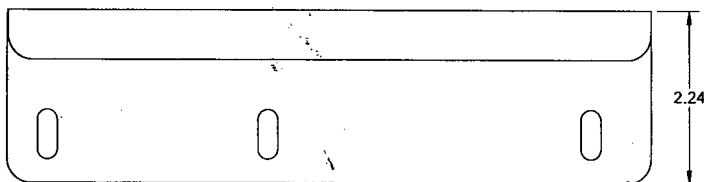
**PRELIMINARY ISSUE**

11.02.18

## **NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH  
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    |          | DRAWING NO.  | REV. PD1     |
| MFG. APPR. |          | D3199  | SHEET 4 OF 4 |
| APPROVED   |          | TITLE  | SCALE        |
| DE APPR.   |          | BRACKET  | NTS          |
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**D3199-3 BRACKET**  
MADE FROM D3199-3F

**PRELIMINARY ISSUE**

11.02.18

*White 25*

**NOTES:**

- 1) MATERIAL: MADE FROM D3199-3F
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    |          | DRAWING NO.  | REV. PD1     |
| MFG. APPR. |          | D3199  | SHEET 2 OF 4 |
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**Linda Lacelle**

**From:** Marc Bellavance <mbellavance@dartaero.com>  
**Sent:** February 22, 2011 2:50 PM  
**To:** Lacelle, Linda; Duval, David  
**Cc:** Petsche, Mike; Shepherd, David; Fauteux, Melanie  
**Subject:** D412-698-027/-028/-037/-038

**Importance:** High

Linda/David,

I have loaded PDF copies of D3199 and D3675 both at revision PD1 here.  
Affected DXF's (D3199-3F and D3675-5F) can also be found there.

Please have qty(1)kit -027/-037 made and shipped to Calgary (attention David and/or Harvey?). Not sure if -028/-038 are required.  
Would be great if we could get those kits shipped to Eagle before end of this week for trial fit since they have an aircraft equipped with composite doors at their disposition.

Thanks!

**Marc Bellavance**  
**Technical/Shop Support**

**DART** aerospace Ltd.

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Fax: 613-632-9311

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Web: [www.dartaero.com](http://www.dartaero.com)

**Product Documentation: Verify Revision Status/Download HERE!**



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